

Date: Tuesday, 04/11/2008 8:33:59 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PANEL-W/O ROTOR BRAKE	
Job Number	: 43177		Part Number	: D38211	
Estimate Number	: 13583		Drawing Number	: D38211 UNDER REVIEW	
P.O. Number	:		Project Number	: IN0002	
This Issue	: 04/11/2008 S.O. No. :		Drawing Revision	: A UNDER REVIEW	
Prsht Rev.	: NC		Material	: MKYDEX 6185S80P362015	
First Issue	: / /		Due Date	: 14/11/2008 Qty: 2 Um: EACH	
Previous Run	: 42065				
Written By	:				
Checked & Approved By	:				
Comment	: Est. A New Issue 08/09/17 DL				

Additional Product

POSITIVE
RECALL

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MKYDEX6185S80P362015	Kydex velour matte, ivory	
		Comment: Qty.: 13.2489 sf(s)/Unit Total : 26.4978 sf(s) Kydex velour matte, ivory	M 109703
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	
	1) Machine set up		08/11/04 Wh
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	Y2
	1) Cut sheet to required blank size		08/11/04 Wh
4.0	THERMOFORMING	THERMOFORMING MACHINE	
		Comment: THERMOFORMING MACHINE	X2
		Thermoform as per Dwg. D3821-1 and folio (FTA 9053 Prototype) using tool DT 9053	
	Dwg. Rev. <u>A UNDER REVIEW</u>		
	Folio Rev. <u>A</u>		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	X2
		Visually inspect for proper formation of each part	08/11/04 NL P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-16	S-O	1 part scrap. Part was formed AS per mold & mold had aluminum trim rails that do not match the drawing. R-C: Tooling 1st time in use..	1051012	→ Scrap & destroy → remove aluminum rails on mold.			1051012	08-12-16

NOTE: Date & initial all entries

Date: Tuesday, 04/11/2008 8:33:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-W/O ROTOR BRAKE

Job Number: 43177

Part Number: D38211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

Box/12/15 (x)

7.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Box/12/15 (x)

8.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0 QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**

pt 08.12.22

Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

*NOT FOR STOCK, TESTING
pt 08.12.22*

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



POSITIVE RECALL

~~EFFECTIVE 08.11.04 AUTH 4~~

~~RELEASED _____ DATE _____~~

*LANCEL
pt 08.12.22*

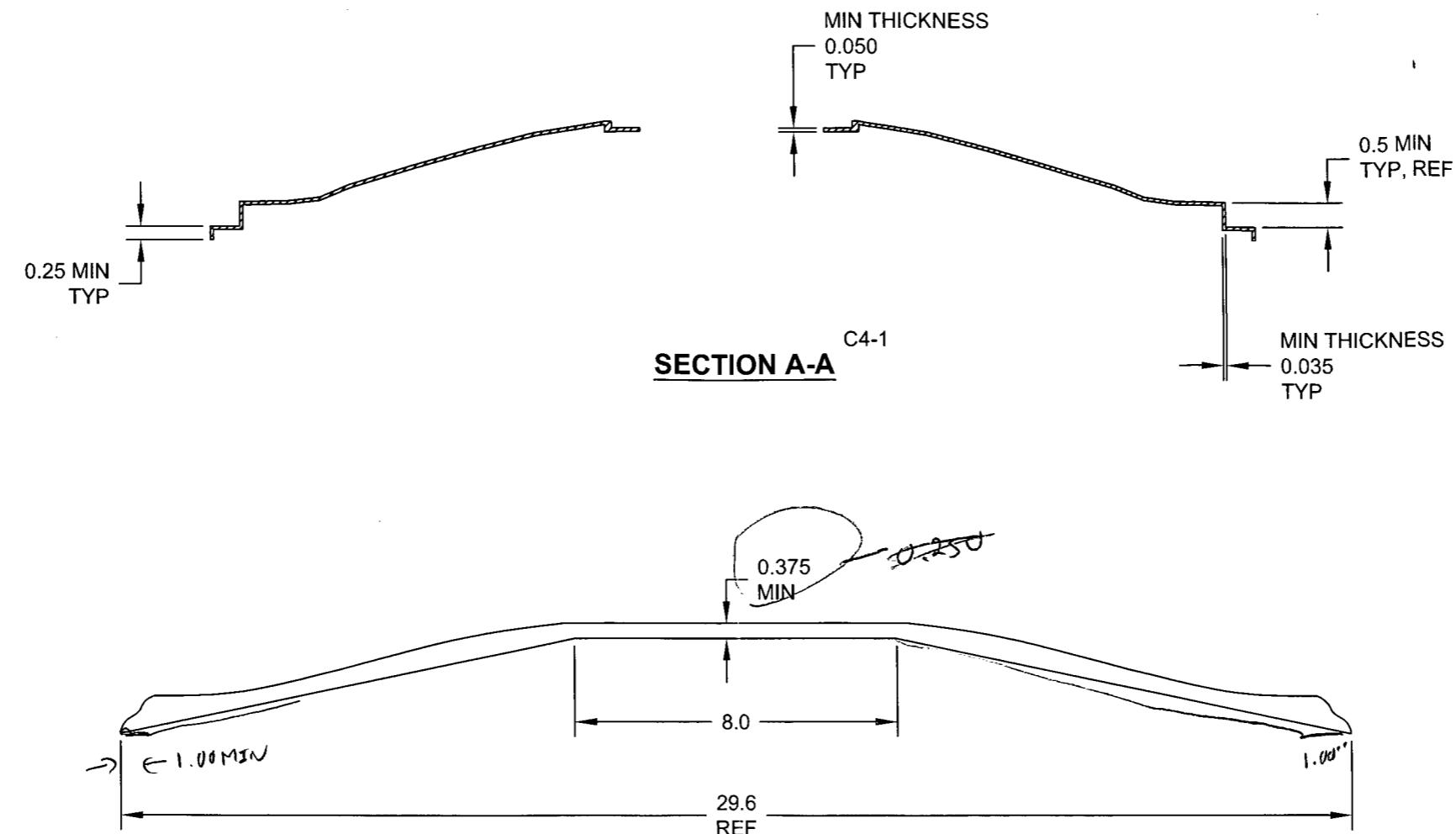
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3821	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	08.09.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD	Work Order:	43177
Description: PANEL w/o Rotor Brake	Part Number:	D3821-1
Inspection Dwg: D3821 Rev: A		Page 1 of 1

2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/12/15

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.040	Min.	0.061	—			20.08" mat'l
29.5 (Ref)	+/- 0.100	30.25	✓			Revise dim.
27.5 (Ref)	+/- 0.100	28.125	✓			Revise dim.
31.8 (Ref)	+/- 0.100	31.5	—			Revise dim/should not be ref
3.0 (Ref)	+/- 0.100	3.0	✓			
100" Typ.	+/- 0.01/-0.25	0.80	—			
2.2 (Ref)	+/- 0.100	2.2	—			Should not be ref
4.6 (Ref)	+/- 0.100	4.75	—			Revise dim/should not be ref
6.1 (Ref)	+/- 0.100	6.1	—			
0.7 Typ.	Min.	0.625	✓			Revise dim (will achieve 2.2)
19.0 (Ref)	+/- 0.100	19.0	—			Should not be ref.
20.5 (Ref)	+/- 0.100	20.500	✓			4.6

Measured by: /

Date: 08-12-15

Audited by: /

Date: 08.12.15 /

Prototype Approval: /

Date: /

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order: 43177
Description: Panel w/o Rotor Brake/prototype	Part Number: D3821-1
Inspection Dwg: D3821 Rev: A	Page 1 of 1 20P2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching	N/A			

Measured by: _____ Date: _____

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.4 (Ref)	+/- 0.100	1.4	✓			
1.9 (Ref)	+/- 0.100	2.0	✓			Revise dim
2.5 (Ref)	+/- 0.100	2.55	—			
31.2 (Ref)	+/- 0.100	30.875		✓		Revised dim/should not be ref.
0.25 typ	Min	0.3	✓			
0.050	Min	0.055	✓			
0.5	Min	0.53	—			
0.035	Min	0.052	✓			
0.375	Min	0.380	✓			
8.0	+/- 0.100	8.0	—			

Measured by: _____ Date: 08.12.16

Audited by: _____ Date: 03.12.16 } RS

Prototype Approval: _____ Date: } PY

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	